

ABSTRACT OF THE DISCLOSURE

A method and apparatus that produces shaped and laminate articles and recovers the excess material or flash as a part of the manufacturing process. The apparatus uses a combination of rotary die and anvil roller assemblies in successive multiple stations to cut and separate each raw material into final product portions and recyclable flash portions as each raw material enters the apparatus. The apparatus separately reclaims each raw material flash portion and delivers the flash of each material in a recyclable form to an auxiliary recycling operation. In recovering the flash, the apparatus does not adversely affect the speed or quality of production of the final shaped or laminated product. To ease removal of the flash, the apparatus applies lubricant to the blades of the rotary die. To avoid damage to web material, the apparatus uses vacuum belts to convey the web material and web product through the apparatus.

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